

Work Order ID 109161

109161

Page 1

November-12-13 2:55:45 PM

Item ID: D412-742-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Start Date: 11/12/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/12/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:  Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

0.00



100

DOCUMENT CONTROL

0.00

DC

Memo

Document Control

If D412-742-041 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-041 CHG005

DAS
6 B6/14
9-89



Work Order ID 109161

November-12-13 2:55:45 PM

109161

Page 2

Item ID: D412-742-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Stop ***NS2***

Start Date: 11/12/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/12/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

HandFinish

Hand Finishing

HandFinishing

Memo

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/RSikaflex-241/-291 11127110
Expiry date: 11/29

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.
A/RSikaflex-241/-291 11127110
Expiry date: 11/29

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
A/RLPS Procyon 11122900

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

1 x of 11/11/13

1 **DAS 05** 11/11/13

Work Order ID 109161***109161***

Page 3

November-12-13 2:55:45 PM

Item ID: D412-742-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Start Date: 11/12/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/12/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							DAS 6 9-89
130									
Packaging	Memo	0.00			DAS 31 9-89			13/11/14	
Packaging	Identify and pack for shipping as per PPP D412-742-041								
	Location: <u>7-6</u> <u>073</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/11/18
me
13-11-15

Picklist Print

November-12-13 2:55:43 PM

Page 1

Work Order ID: 109161

Parent Item: D412-742-041

Start Date: 11/12/13

Required Date: 11/12/13

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP rev D 07.11.01 ecn 1053p EC
 IPP rev E 07.11.27 ecn 1072 EC verified by:DD
 IPP Rev:F 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:G 10.02.24 as per ECN10-
 514 DD verified by: EC IPP Rev:H 11.11.01 as per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-011 Fwd Tube Assembly		Manufactured	No			110	Each	0.0000	1	1		13/11/12	
D3391-015 Aft Tube Assembly		Manufactured	No			110	Each	0.0000	1	1		13/11/12	
AN3C4A Bolt		Purchased	No			110	Each	4,039.0000	24	24		13/11/12	

Location

Loc Qty

Loc Code

FG	20	
122814	20	
ST350	1593	
M127363	593	
M127410	1000	
ST512	2426	
125388	2376	
M126765	50	

* Mid-Tube Assembly

D3391-013 / B104694

(1x) 13/11/12

D3391.013

Picklist Print

November-12-13 2:55:44 PM

Page 2

Work Order ID: 109161

Parent Item: D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Start Date: 11/12/13

Required Date: 11/12/13

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 110 Each 795.0000

10 10 12/11/12

Bolt

Location Loc Qty Loc Code

FG 10

122416 10

FP001 30

122599 30

FP002 1

111982 1

ST351 17

122416 17

ST512 737

m125709 737

AN3C7A Purchased No 110 Each 943.0000

4 4 13/11/12

Bolt

Location Loc Qty Loc Code

FG 10

122141 10

FP001 1

122800 1

ST351 10

123900 6

124221 4

ST511 922

m125709 922

November-12-13 2:55:44 PM

Shop Packet Print

Page 2

Picklist Print

November-12-13 2:55:44 PM

Page 3

Work Order ID: 109161

Parent Item: D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Start Date: 11/12/13

Required Date: 11/12/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

110

Each

12,767.000

38

38

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	264	
-------	-----	--

123355	264	
--------	-----	--

ST292	119	
-------	-----	--

123248	18	
--------	----	--

123759	10	
--------	----	--

125268	91	
--------	----	--

st510	10584	
-------	-------	--

m126319	5084	
---------	------	--

m127306	2500	
---------	------	--

m127410	3000	
---------	------	--

ST511	1674	
-------	------	--

125654	1674	
--------	------	--

ST517	126	
-------	-----	--

124580	126	
--------	-----	--

MS27039C4-12

Purchased

No

110

Each

193.0000

4

4

SCREW

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST309	193	
-------	-----	--

124586	193	
--------	-----	--

November-12-13 2:55:44 PM

Shop Packet Print

Page 3

Picklist Print

November-12-13 2:55:44 PM

Page 4

Work Order ID: 109161

Parent Item: D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Start Date: 11/12/13

Required Date: 11/12/13

Start Qty: 1.00

Required Qty: 1.00

D3672-3 Manufactured No 110 Each 889.0000
Phenolic Washer

4 ll 4 13/11/12

Location	Loc Qty	Loc Code
FG	111	
84432	11	
89273	100	
FP-001	31	
91915	31	
ST060	747	
<u>107316</u>	71	<u>V4</u>
84432	1	
86517	5	
88441	25	
91915	136	
93925	509	

NAS1149C0432R Purchased No 110 Each 6,194.0000
WASHER

4 ll 4 13/11/12

Location	Loc Qty	Loc Code
ST292	2320	
119124	6	
121255	8	
121825	8	
122441	55	
m125807	2251	
ST510a	3874	
<u>m126221</u>	3874	<u>V4</u>

D4095-041 Manufactured No 110 Each 16.0000
Wearplate Assembly

1 ll 1 13/11/12

Location	Loc Qty	Loc Code
FP002	16	
<u>108286</u>	16	<u>V1</u>

November-12-13 2:55:44 PM

Shop Packet Print

Page 4

Picklist Print

November-12-13 2:55:44 PM

Page 5

Work Order ID: 109161

Parent Item: D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & Oem Cylindrical Float Compatible

Start Date: 11/12/13

Required Date: 11/12/13

Start Qty: 1.00

Required Qty: 1.00

D4095-043 Manufactured No 110 Each 11.0000 1

Wearplate Assembly

1 13/11/12

Location

Loc Qty

Loc Code

FP002

11

106162

2

108287

9

D4095-045

Manufactured No

110 Each 17.0000 1

Wearplate Assembly

1 13/11/12

Location

Loc Qty

Loc Code

FP002

17

108288

13

77737

1

84081

1

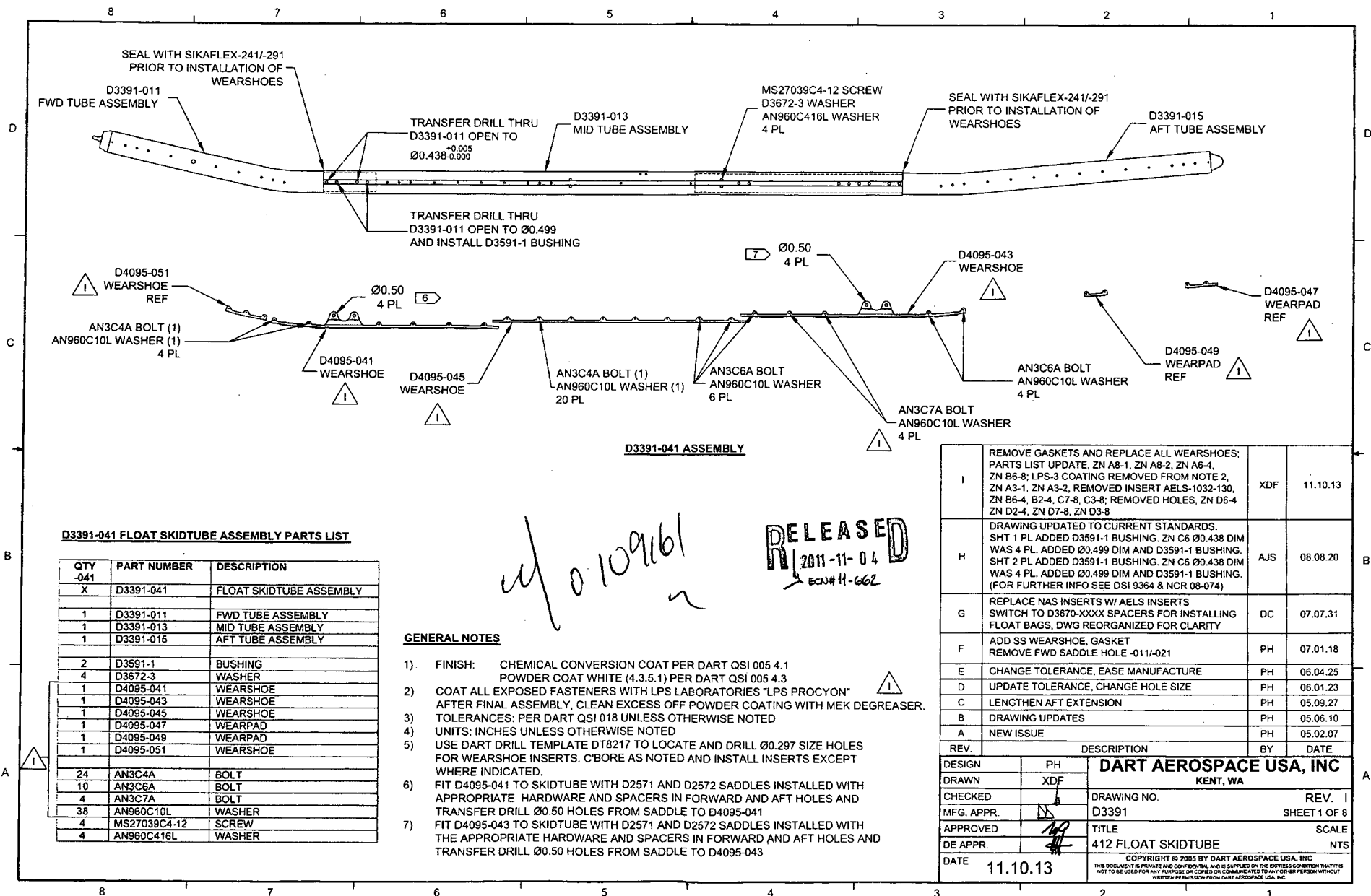
93054

2

November-12-13 2:55:44 PM

Shop Packet Print

Page 5



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

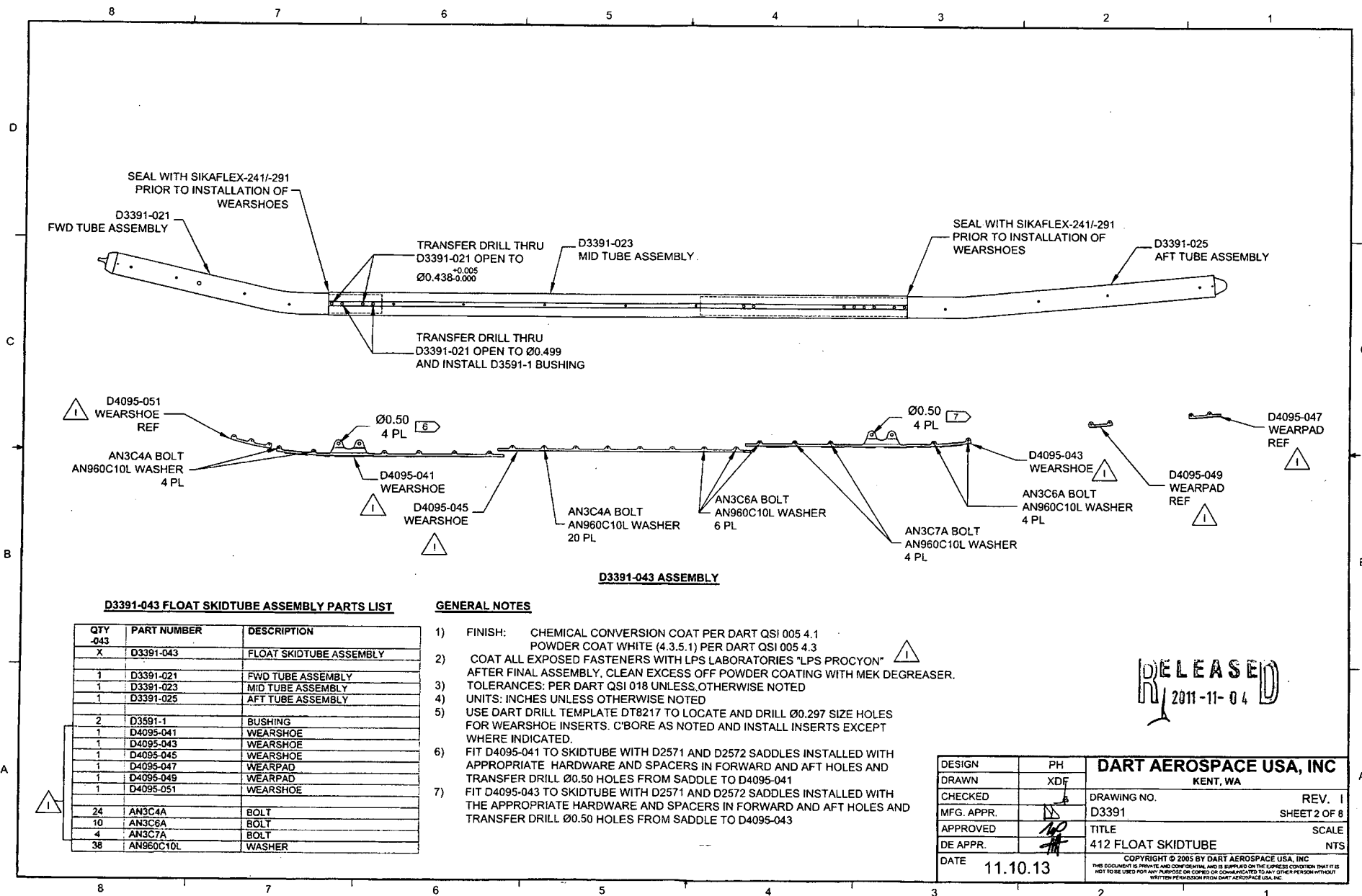
QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

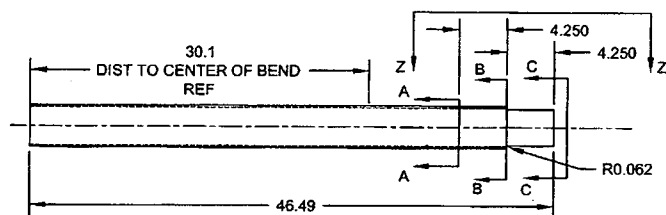
GENERAL NOTES

- 1). FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2). COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3). TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4). UNITS: INCHES UNLESS OTHERWISE NOTED
- 5). USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6). FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7). FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

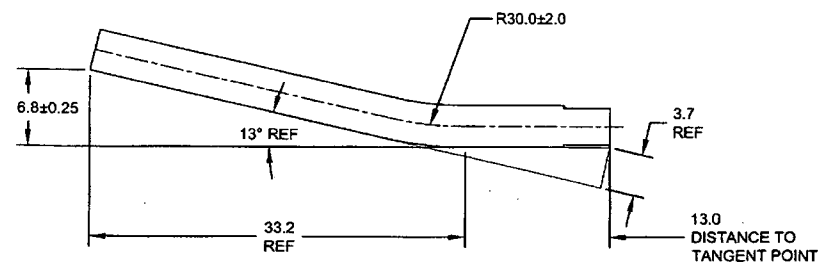
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.13		

DART AEROSPACE USA, INC KENT, WA	
DRAWING NO. D3391	REV. I SHEET 1 OF 8
TITLE 412 FLOAT SKIDTUBE	SCALE NTS
COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR OTHER PURPOSE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

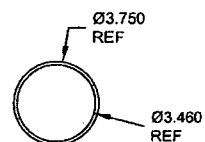




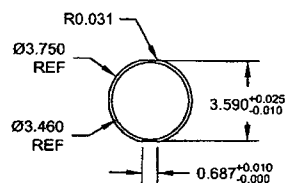
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



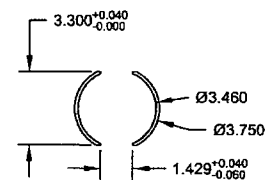
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



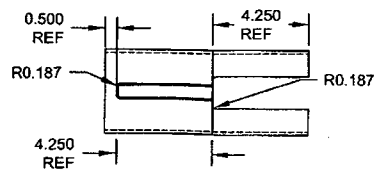
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



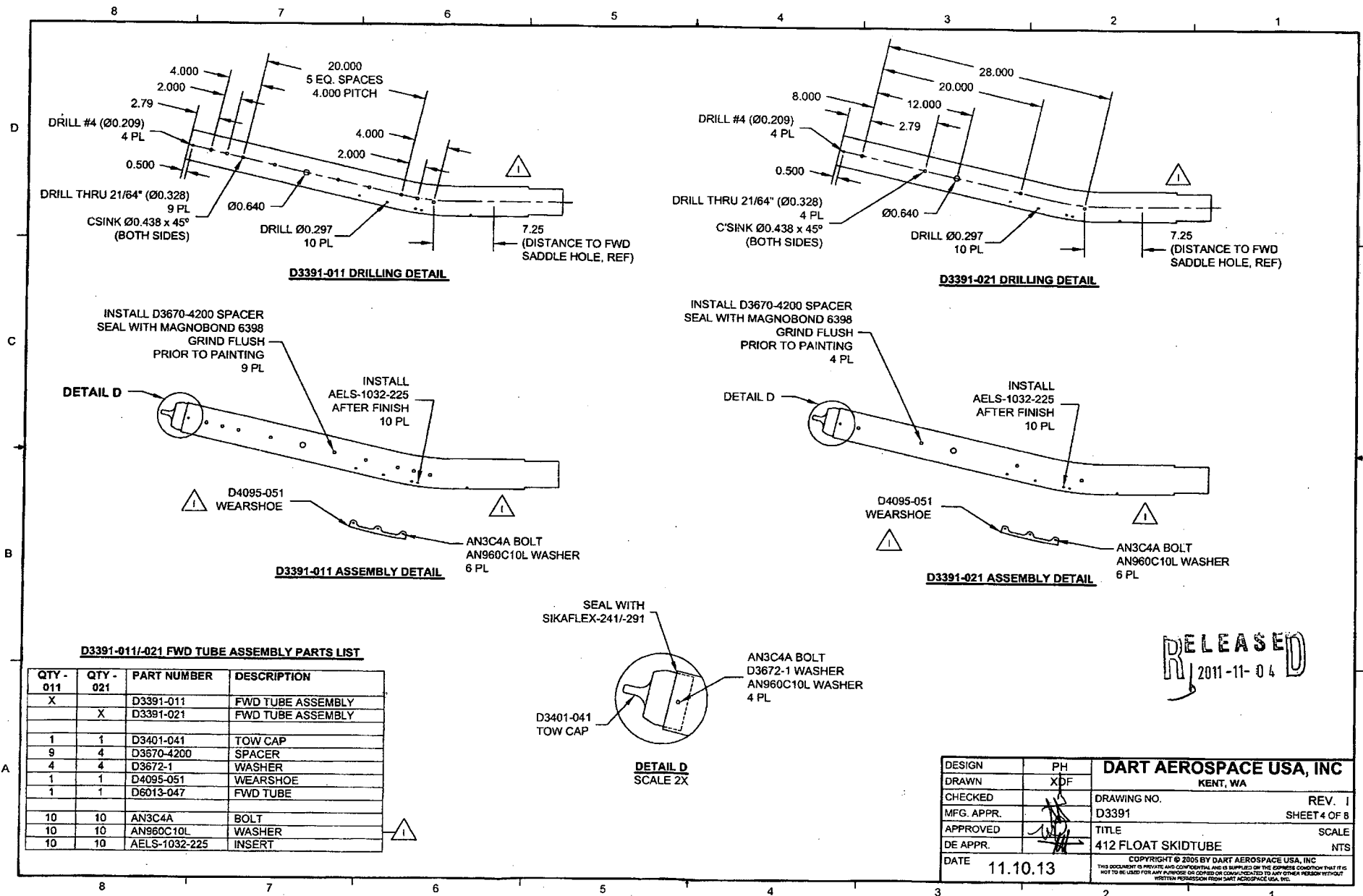
SECTION C-C
SCALE 2X

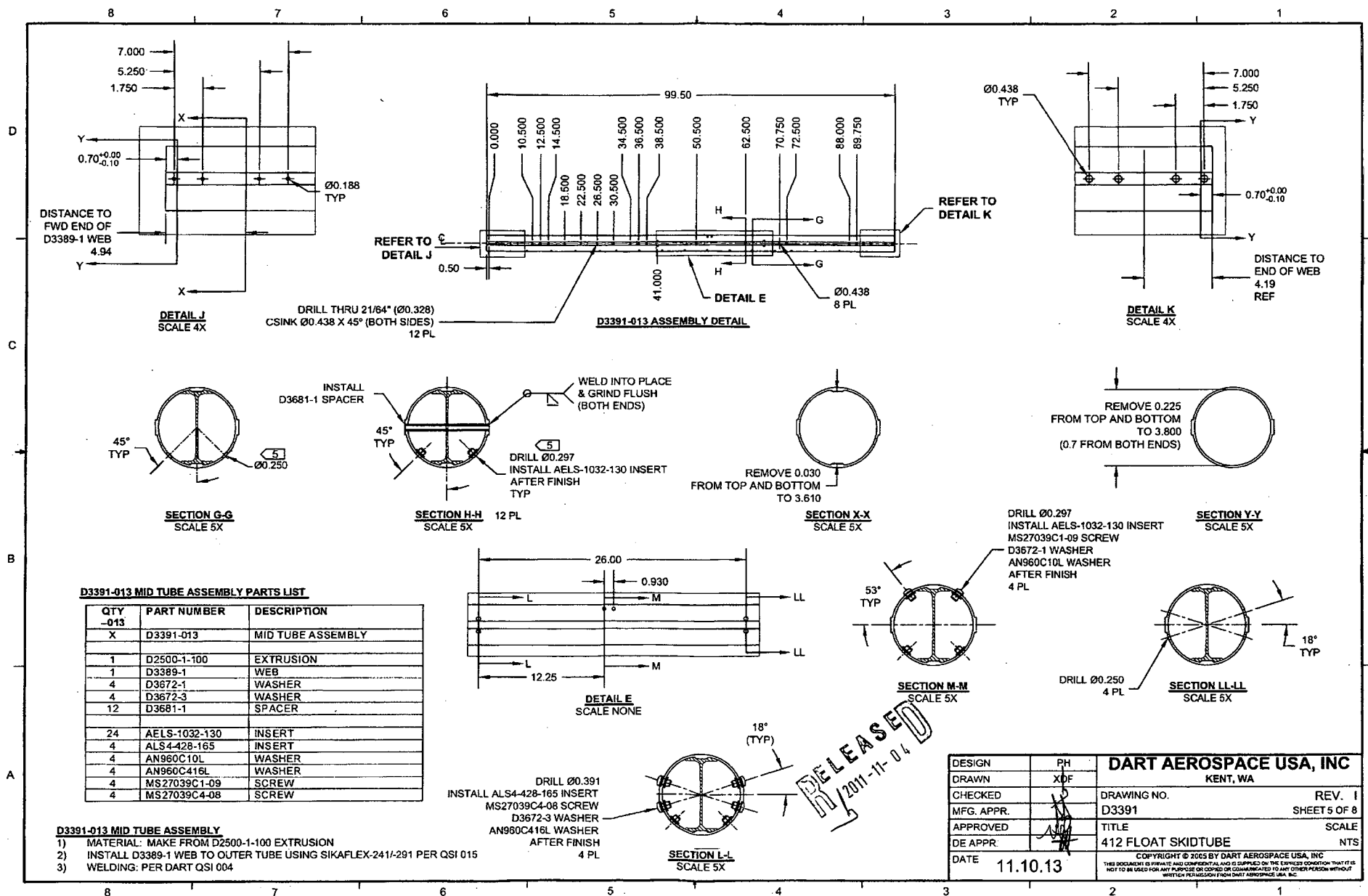


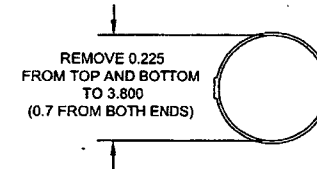
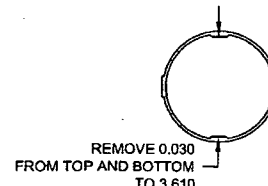
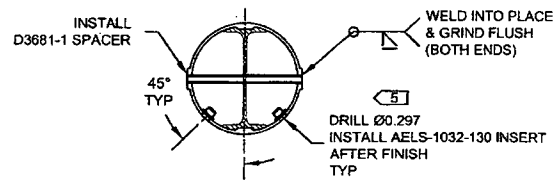
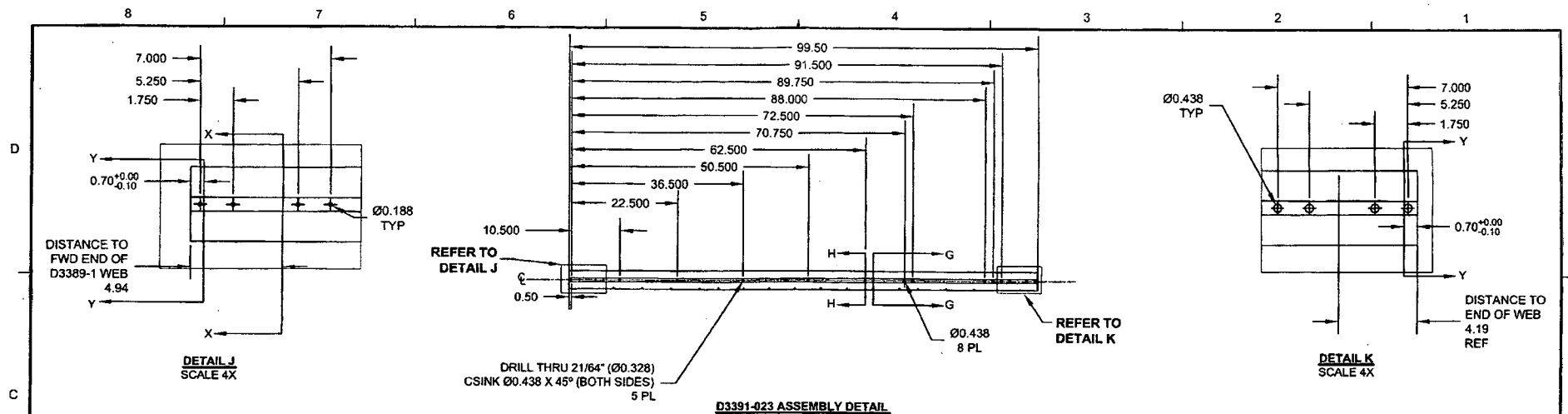
VIEW Z-Z
SCALE 2X

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	







D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT MAY NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

